

Date: Monday, 8/13/2007 1:01:58 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 33877	
Estimate Number : 10791	
P.O. Number : N/A	Part Number : D3282041
This Issue : 8/13/2007 S.O. No. : N/A	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 33656	Material : N/A
Written By : <i>[Signature]</i> 07-08-13	Due Date : 8/20/2007 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

*B-33518 AWM 07/08/13*

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

*AWM 07/08/13*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Debur

*J.F. 07/08/17* (4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/08/17* (4)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK
















*EC 07.08.17* (4)



Date: Monday, 8/13/2007 1:01:58 PM  
User: Jean-Luc Menard

## Process Sheet

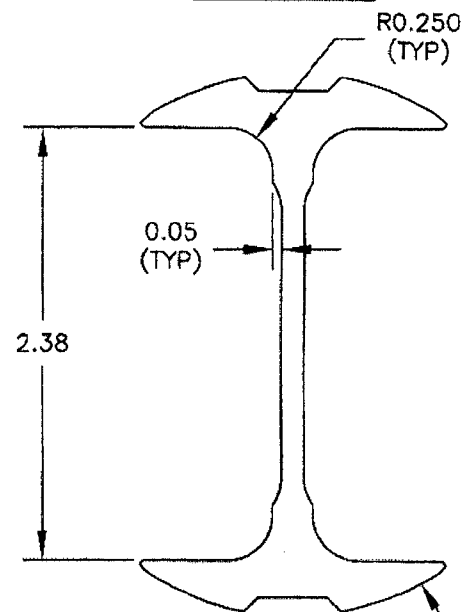
Customer:  
Job Number:  
Job Number:  
Seq. #:  
13.0  
Commer

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT WEB	
Job Number: 33877		Part Number: D3282041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			
8.0	D32831	Doubler	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3283-1 Doubler			
9.0	MS20470AD47	Rivet, Universal Head	
			
Comment: Qty.: 57.0000 Each(s)/Unit Total : 228.0000 Each(s) Pick: Qty Part Number Description Batch 57 MS20470AD4-7 Rivet			
10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web A/RN/ALPS-3			
11.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
12.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG			

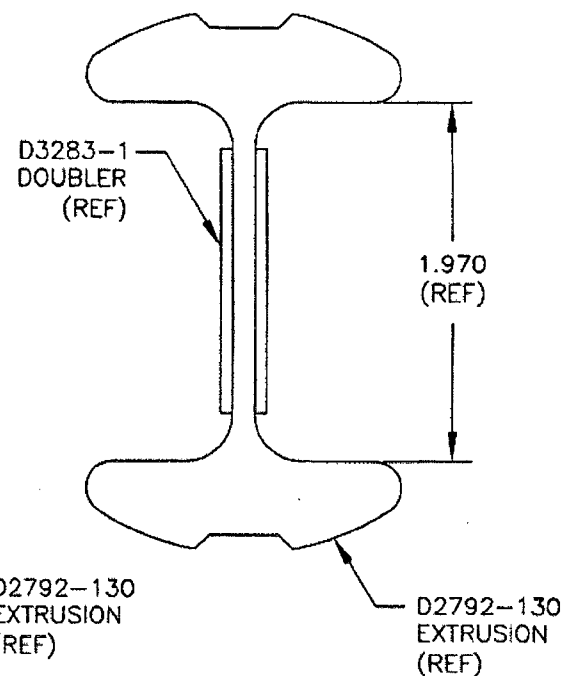


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE	1:20	

### SECTION A-A

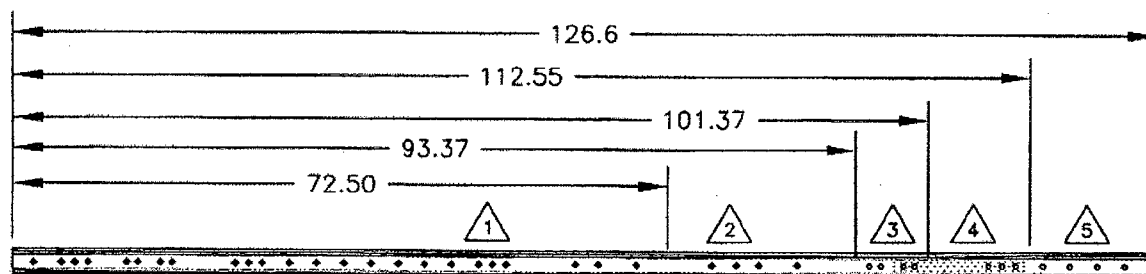


### SECTION B-B



### D3282-1 MACHINING NOTES

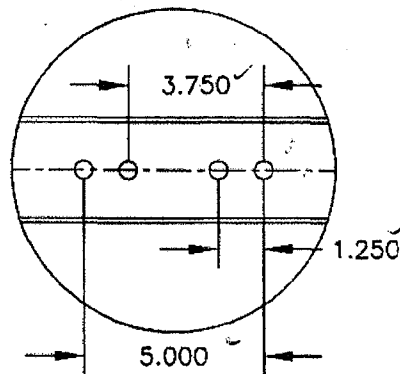
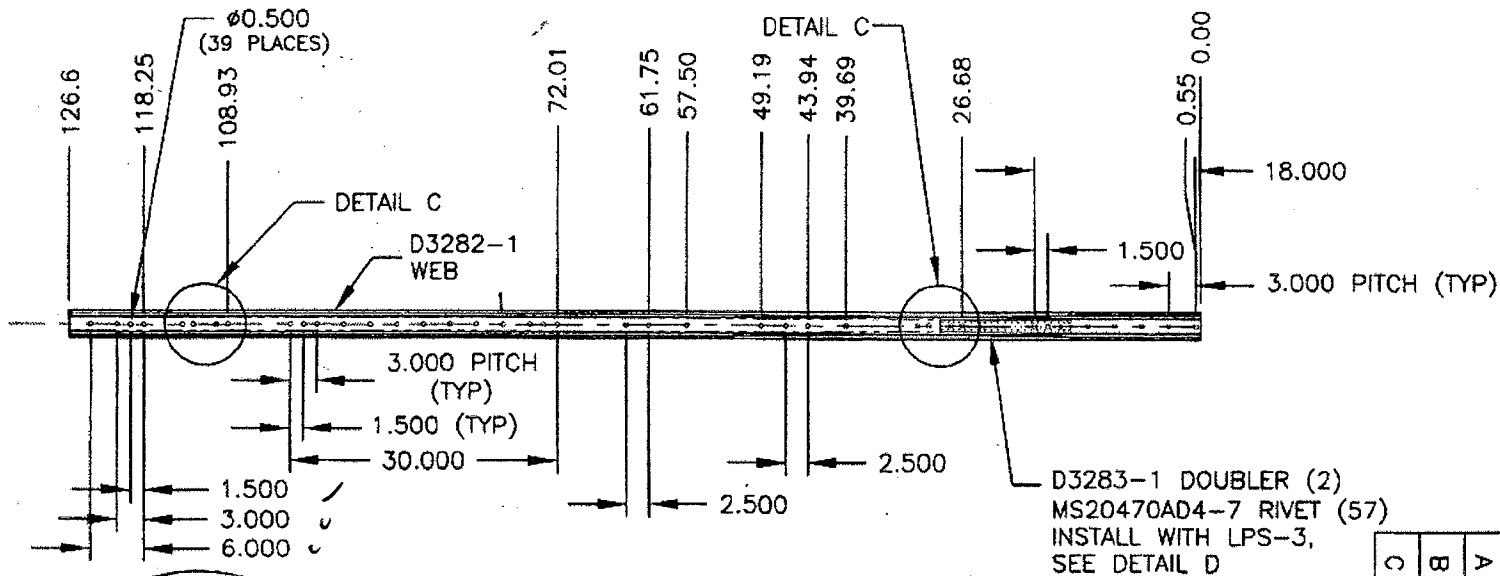
- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 ( $\phi 0.128$  REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



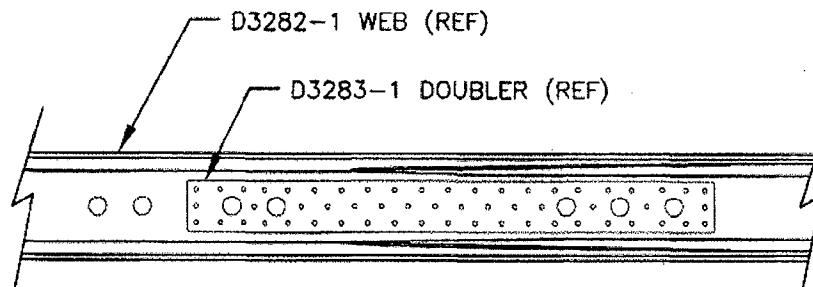
RELEASED  
05-04-12



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3282
DATE		TITLE
05.08.09		SCALE
		1:20
A	04.05.05	NEW ISSUE
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
C	05.08.09	REMOVE D3390-1, NOW MACHINED



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

#### D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED  
05.09.12

DART AEROSPACE LTD		Work Order: 33877
Description: Float web		Part Number: 03282-1
Inspection Dwg: 03282 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A .050"	±.030"	.040"	✓			
B 2.38"	±.030"	2.376"	✓			
C R .0250"	±.010"	R .250"	✓			
D .55"	±.030"	.556"	✓			
E 3.000"	±.010"	3.002"	✓			
F 3.750"	±.010"	3.749"	✓			
G 1.250"	±.010"	1.249"	✓			
H 5.000"	±.010"	4.998"	✓			
I Ø.500"		Ø.501"	✓			
J 1.500"	±.010"	1.499"	✓			
K 2.500"	±.010"	2.500"	✓			
L 6.000"	±.010"	5.995"	✓			
M 126.6	±.100"	126.6	✓			
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: J.F.	Audited by: SA	Prototype Approval:	N/A
Date: 07/08/16	Date: 01.08.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

11/11/11

11/11/11

11/11/11

11/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-22	10.0	1 rivet hole was enlarged when a rivet was removed. Drill bit wandered on the last hole of Assembly, resulting to • 148 R.C. Drill bit wandered; human error.	<i>QS1042</i>	Remove the rivet and enlarge the hole to 0.151", install 2x MS20470ADS-7 rivet to replace original in the 2 corners. B# <u>M2655</u> . <u>Acceptable dimension</u>	<i>2823</i>	<i>Em</i> 07/08/22	<i>QS1042</i>	<i>070822</i>

NOTE: Date & initial all entries